

5/25

Split B

DART AEROSPACE LTD	Work Order:	23257
Description: Plug	Part Number:	D2594-1
Dwg: D2594 Rev. B1	Qty:	300 Z68
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	SP	05/05/10	300
2	MC	Make as per Dwg D2594-1 and Folio FA262. Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625)			
3	MC	Break all sharp edges 0.010 max.	ML	05/05/12	300
4A	QC2	Inspect dimensions as per drawing D2594	ML	05/05/12	300
4B	QC8	Second check	ML	05/10/24	300
5	FP	Acid etch and alodine as per QSI 005 4.1	FC	05/11/02	300
6	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)	M	05/11/09	268
7	QC3	Inspect Powder Coat	CD	05/11/09	268
8	FP	Identify and Stock	M	05/11/09	268
9	AC	Cost / part .95	SU	05/11/09	268
10	DC	Close W/O , 89 Inspect Level 21	KJ	05/11/16	268

Rev	Date	Change	Revised By	Approved
A	98.11.27	New Issue	DM	
B	00.11.01	Removed P/O for Powder Coat – in house process	EC	
C	01.07.17	Reformat step 2	SM	
D	02.08.22	Make in Cobra	KJ RF	

RELEASED
02/03/22 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No

Date: 05/11/11

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

5/25

DART AEROSPACE LTD	Work Order:	23257
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

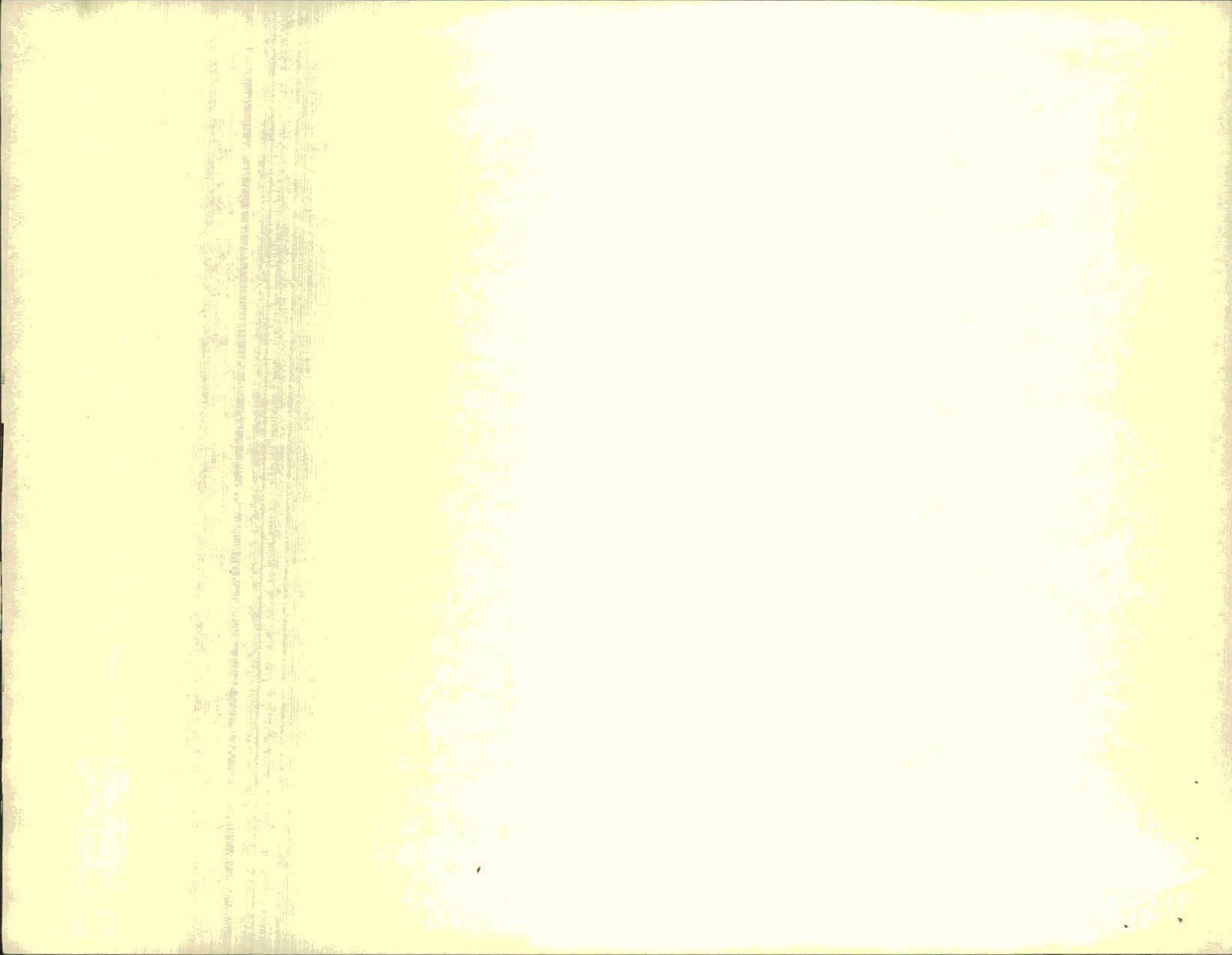
First Article Prototype

Measured by:	<i>gml</i>	Audited by:	<i>EP</i>	Prototype Approval:	N/A
Date:	05/10/17	Date:	05/10/17	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	[Signature]

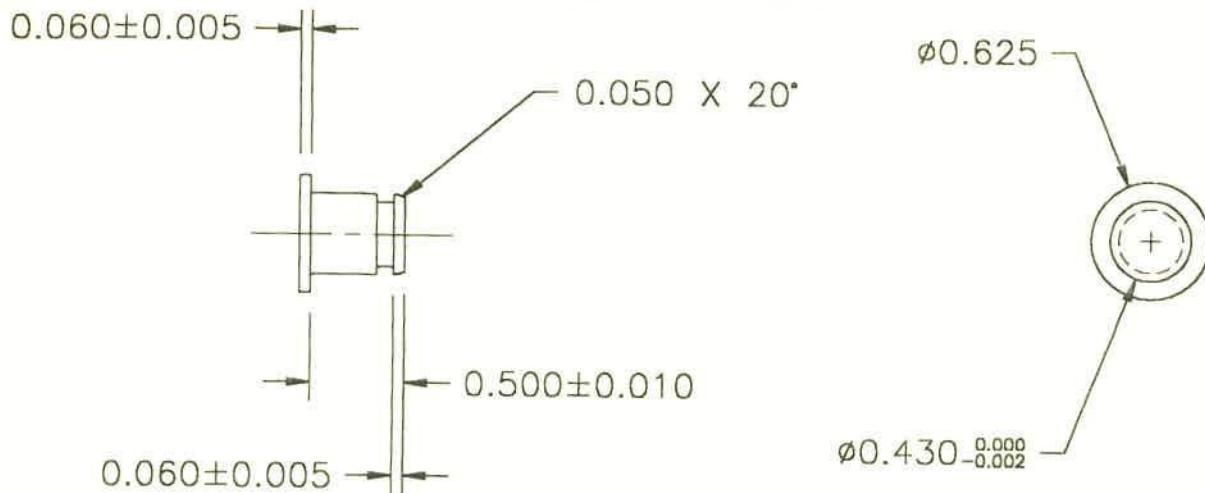
RELEASED

04.03 24



DART

DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>DMY</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	ADD Powder Coat, QSI 018, & QQ-A Specs.	

D2594-1 PLUG:**RELEASED**
97/03/27 DS

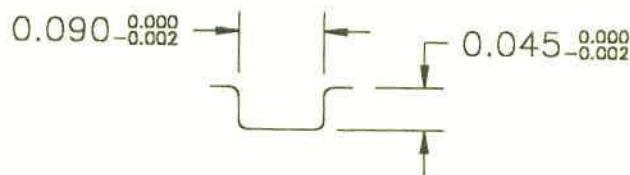
SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 93251GROOVE DETAIL (SCALE 5:1)

TOLERANCES ARE PER DRAFT QSI 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

FINISH: ACID ETCH, ALODINE

Powder Coat White (Ref. 43.5.1) per QSI 005 4.3

(B1)

PER QQ-A-225 /7 (5052)
OR QQ-A-225 /8 (6061)
OR QQ-A-225 /1 (1100)
OR QQ-A-200 /8 (6061)

(B1)

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)D2594 PLUG ASSEMBLY INCLUDES: {1} D2594-1 PLUG
{1} D2594-3 O-RING



Job Costing Report

Dart Aerospace Ltd.
HawkesburyMay 10, 2005
01:31 pm

Work Order No : 0023257
 Project Name : D2594-1
 Project For : WK525
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2594-1
 Description : Plug
 Manufactured : Yes
 Amount Req'd : 300
 Amount Done : 0
 Start Date : 05-10-05
 Est Finish Date : 06-18-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

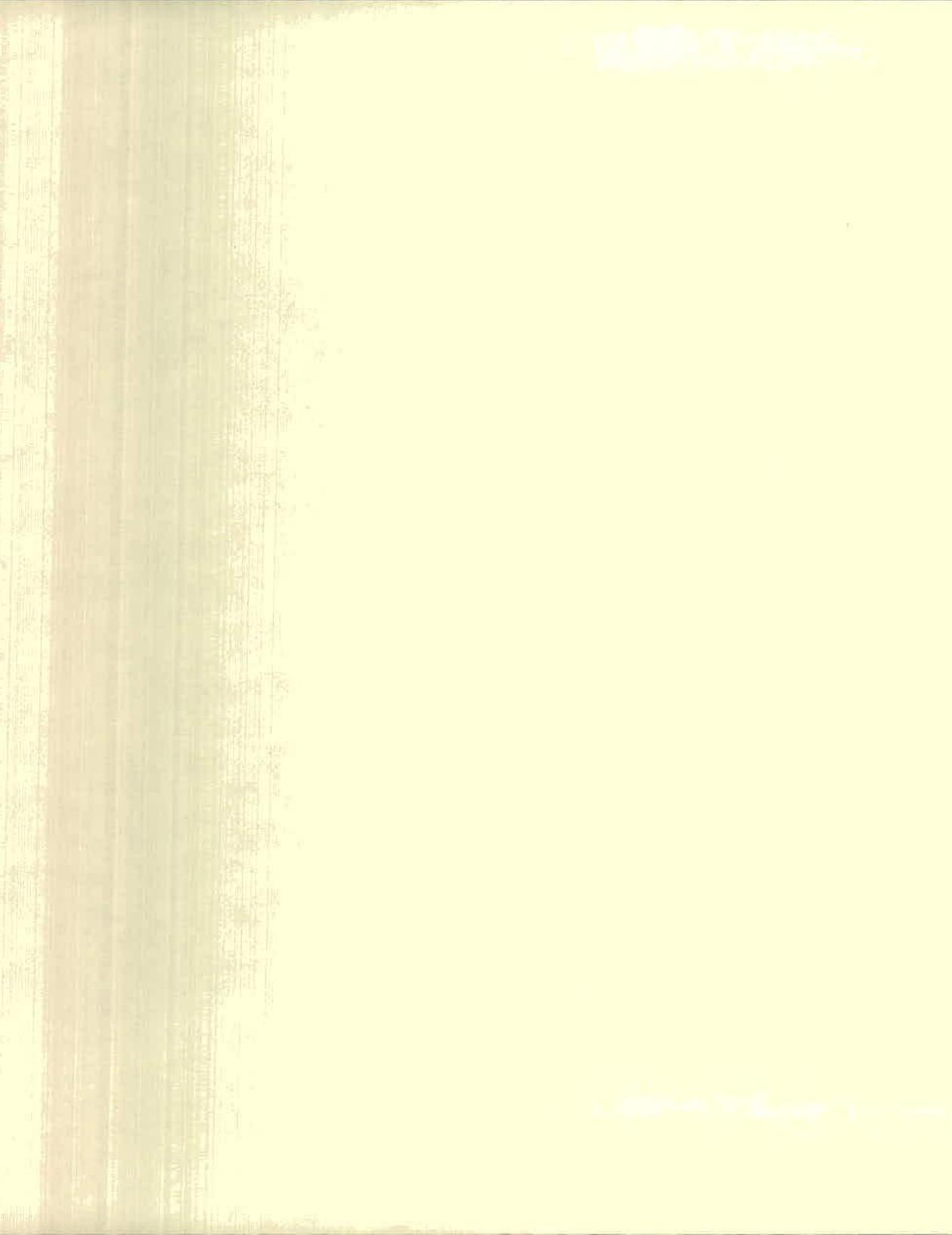
Date: Thursday, 11/10/2005 7:57:43 AM
User: Linda Lacelle

**INVENTORY ITEMS PICKED
FOR SLIP NUMBER 11**

Project No. : Drawing Number : D2594 REV B1
Customer : Dart Helicopters Services Drawing Name : PLUG
Part Number : D25941 Due Date : / /
Job Number : 23257 Qty : 268
Slip # : 11

	Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
1.0 M6061T6R0625 6061-T6 Round Bar .625" Available 70.17	MAIN			16807	14.66	14.6600 f	

1000 m/s. The effect of the main magnetic field on the particle motion is shown in Fig. 6.



As the magnetic field increases, the effect on the particle motion becomes more pronounced. For example, at $B = 10^4$ G, the particle's motion is almost entirely restricted to the X-axis, as shown in Fig. 7. This illustrates how the magnetic field can confine particles to specific directions or planes in phase space.

Job Costing Report

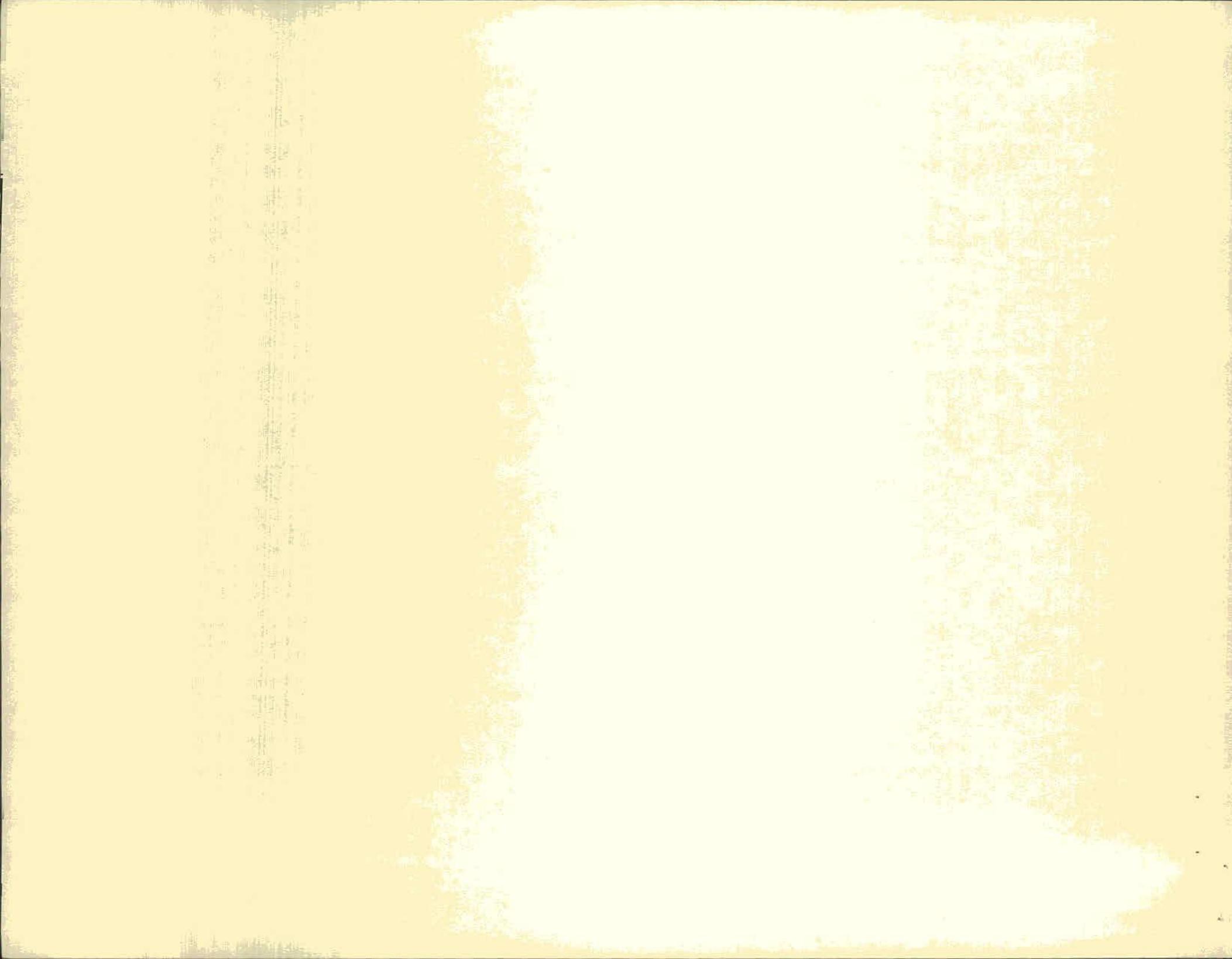
Dart Aerospace Ltd.
HawkesburyNov 08, 2005
10:27 am

Work Order No : 0023257
 Project Name : D2594-1
 Project For : WK525
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2594-1
 Description : Plug
 Manufactured : Yes
 Amount Req'd : 300
 Amount Done : 32
 Start Date : 05-10-05
 Est Finish Date : 06-18-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : Part/All Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	3.60	100.00	3.60	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	12.32	100.00		
Production Cost :	0.00	223.01	100.00	15.24	207.77
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	8.50	100.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	226.61	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	226.61			

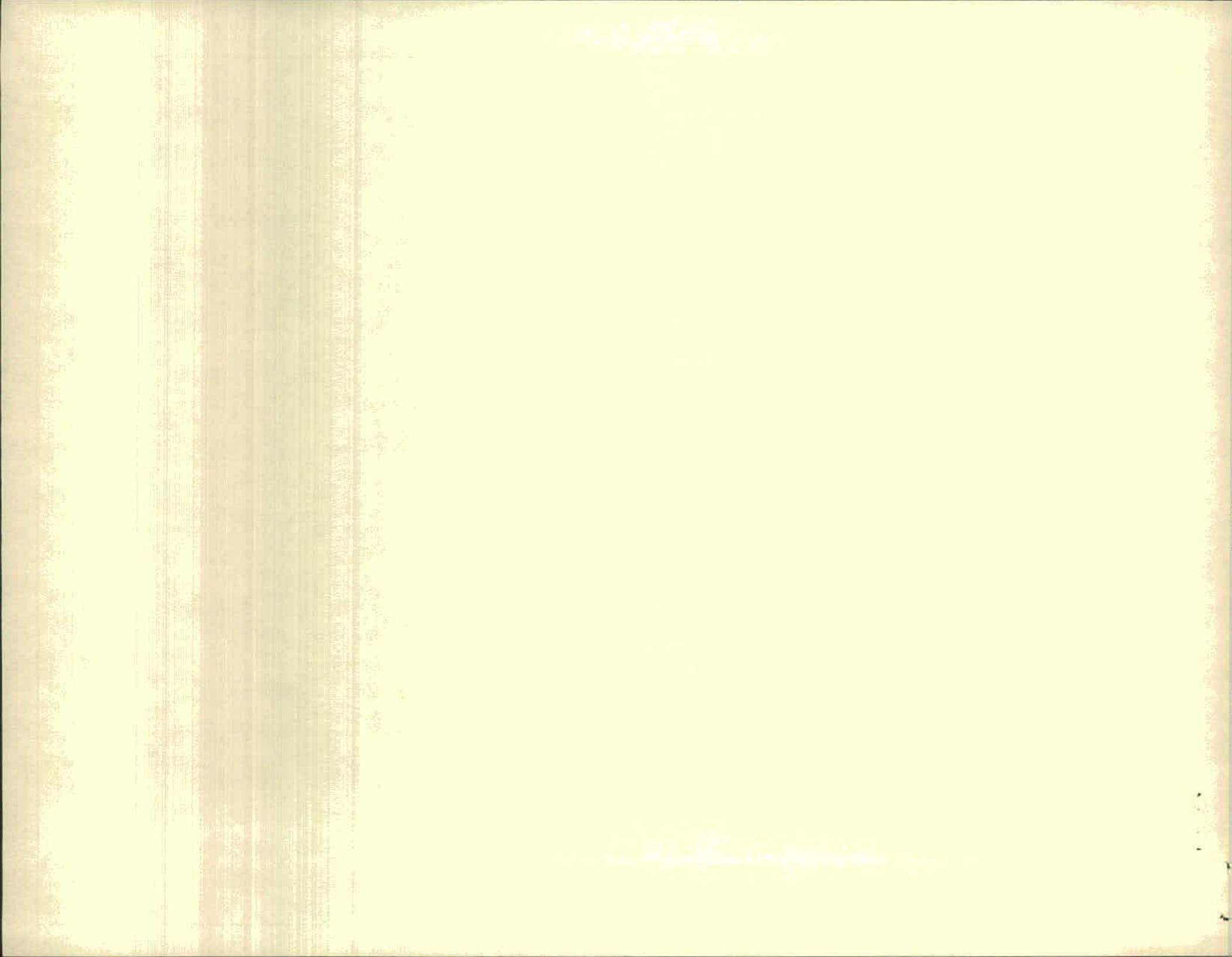
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.65
Profits/ (Loss) :	0.00	(-226.61)



Date: Saturday, 11/5/2005 7:46:15 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 23257		
Estimate Number	: 10178		
P.O. Number	:	Part Number	: D25941
This Issue	: 11/5/2005	S.O. No.	: D2594 REV B1
Prsht Rev.	: NC	Project Number	:
First Issue	: / /	Type	: MACHINED PARTS
Previous Run	:	Drawing Revision	: B1
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 11/30/2005 Qty: 300 Um: Each
Comment	: Est D 02.08.22 Make in Cobra KJ		
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625 	6061-T6 Round Bar .625" Comment: Qty.: 0.0547 f(s)/Unit Total : 16.4115 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) Batch _____ 	
2.0	HARDINGE 	HARDINGE CNC LATHE SMALL Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max. 	
3.0	QC6 	DIMENSIONAL CHECK Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs DIMENSIONAL CHECK 	
4.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 	
5.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs HAND FINISHING RESOURCE #1 Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)	



Date: Saturday, 11/5/2005 7:46:15 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 23257

Part Number: D25941

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0 DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

Job Completion



